

Work Order ID 82181

March-23-12 1:25:19 PM

30/03
82181

Page 1

Item ID: D3758-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 3/23/12 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 3/30/12 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3758	Rev A
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100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3758-1 Dwg Rev: *A* Prog Rev: *A* 2-
 Deburr if necessary

304.032

B 12-3-24

(32)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-3-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/2/03/26

count
(733)

82181

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N900040100

Setup Start *NS1*

Stop *NS2*

24

Cust Item ID:

24

Customer:

Reference:

Run Start *NR1*

Date:

Stop ***NR2***

Date:

**Insp.
Stamp**

0.00

130

Small Fab

0.00

Small Fab

Small Fab

1- Deburr any rough edges 2- Form as per Dwg D3758

140

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

150

0.00

150

Small Fab

0.00

Small Fab

Small Fab

Memo

Assemble rubber cushion as per dwg D3758

82181

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/23/12 **Start Qty:** 24.00 ***24***

Cust Item ID:

Required Date: 3/30/12 **Req'd Qty:** 24.00 ***24***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling: _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0,00

Quality Control

170

Identify as per dwg & Stock Location: ST 458 0.00

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

RI 04-17

Picklist Print

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Work Order ID: 82181

Parent Item: D3758-041

Parent Item Name: Clamp

Start Date: 3/23/12

Required Date: 3/30/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B028		Manufactured	No			100	Each	0.0000	1	24			
Rubber Cushion													
M304S22GA		Purchased	No			150	sf	143.9000	0.026	0.6568421			
304/316 .032 Sheet													

Location

MAT020

118271

120866

Loc Qty

143.9

14.4

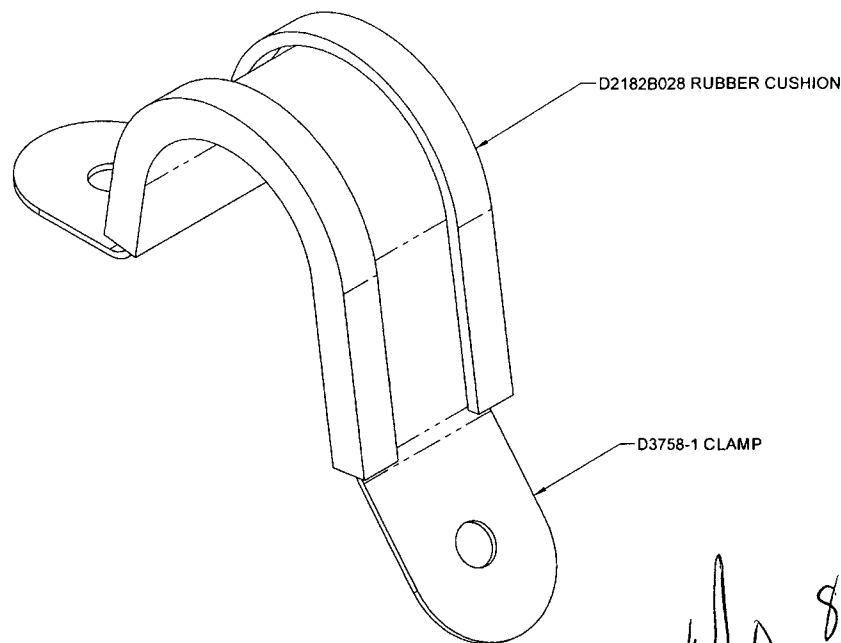
129.5

Loc Code

118271

32

QTY	P/N	DESCRIPTION
041		
X	D3758-041	CLAMP
1	D3758-1	CLAMP
1	D2182B028	RUBBER CUSHION



D3758-041 CLAMP

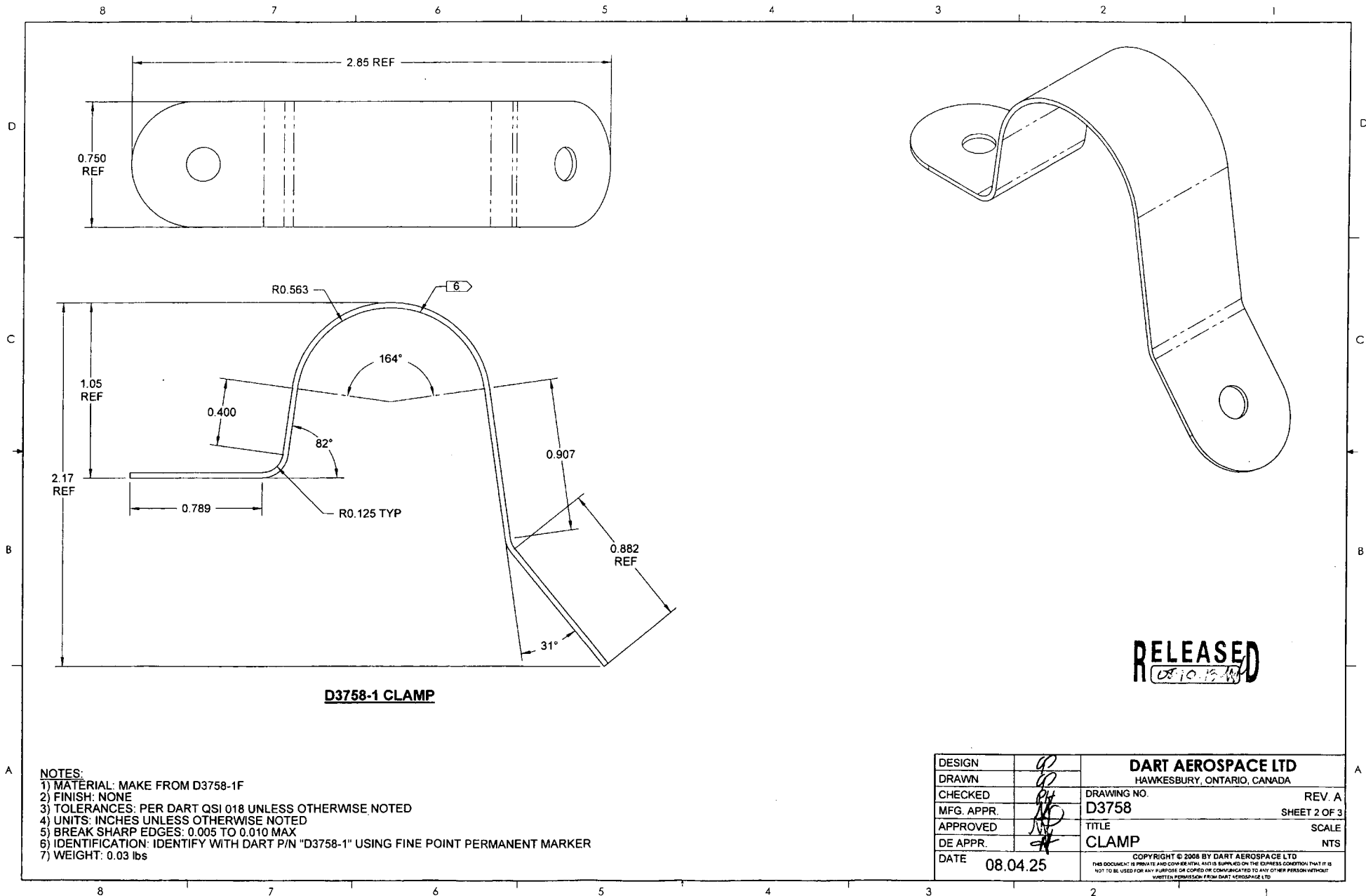
W/O 82181

RELEASED
08-10-15 11:20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

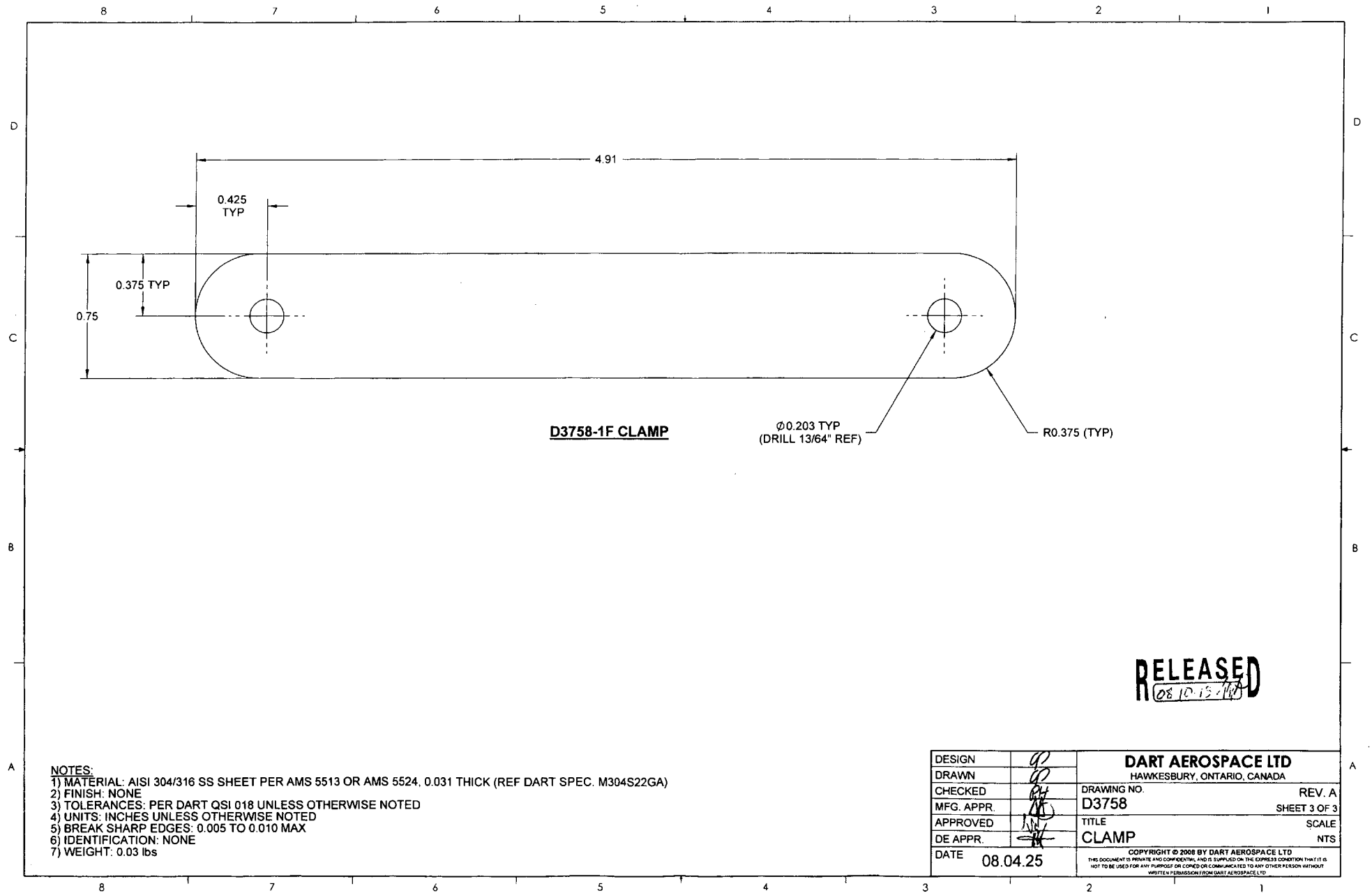
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>GP</i>	D3758	SHEET 1 OF 3
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	CLAMP	NTS
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NOTES:

- 1) MATERIAL: MAKE FROM D3758-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3758-1" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 0.03 lbs

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MFG. APPR.		D3758	SHEET 2 OF 3
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D3758-1F CLAMP

Ø0.203 TYP
(DRILL 13/64" REF)

R0.375 (TYP)

RELEASED
08-10-15-11

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	92	DART AEROSPACE LTD	
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